

Date: Tuesday, 29/07/2008 9:05:12 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	AFT BLADE FOLD ASSY WELDMENT
Job Number :	40772		
Estimate Number :	13503		
P.O. Number :		Part Number :	PB674300109
This Issue :	29/07/2008	Drawing Number :	B6743001 P.6
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	/ /	Drawing Revision :	B1
Previous Run :		Material :	
Written By :		Due Date :	05/08/2008
Checked & Approved By :	<i>CMF 08-07-29</i>	Qty:	<i>3</i> Um: Each
Comment :	Est Rev:A 08-06-25 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	PB6743001211	Square Tubing
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Comment: Qty.: 6.0000 Each(s)/Unit Total : 30.0000 Each(s)
 Square Tubing
 batch:- *340596*

PL 08-07-31 3

2.0	PB6743001209	Square Tubing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
 Square Tubing
 batch:- *340595*

PL 08-07-31 3

3.0	PB6743001201	Square Tubing
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)
 Square Tubing
 batch:- *340592*

PL 08-07-31 3

4.0	PB6743001203	Square Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
 Square Tube
 batch:- *340594*

PL 08-07-31 3

5.0	PB6743001239	Square Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
 Square Tube
 batch:- *340555*

PL 08-07-31 3

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Drawing Name: AFT BLADE FOLD ASSY WELDMENT

Job Number: 40772

Part Number: PB674300109

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	PB6743001235	Outer Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Outer Tube

batch:-

B 40771

Ph 08.07.31 3

7.0	PB6743001229	Outer Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Outer Tube

batch:-

B 40779

Ph 08.07.31 3

8.0	PB6743001213	Flanged Hook
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Flanged Hook

batch:-

~~B 24000~~ *B 40040*

Ph 08.07.31 3

9.0	PB6743001311	Restraint
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Restraint

batch:-

M19695

Ph 08.07.31 3

10.0	PB6743001277	Contoured Hinge Arm
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Contoured Hinge Arm

batch:-

~~B 23828=1~~ *B 40039=3*

Ph 08.07.31 3

11.0	PB6743001243	Handle Arm Extension
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Handle Arm Extension

batch:-

B 40044

Ph 08.07.31 3

12.0	D34409	Tube Detent Clip Base
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Tube Detent Clip Base

batch:-

B 23736

Ph 08.07.31 3

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Job Number: 40772

Part Number: PB674300109

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D344013

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Bracket

batch:- 3240138

08.08.07 3

14.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- assemble parts on jig DT8814 and weld as per dwg PB67-43001

ensure no burn thru after welding in tube -235 and -229

08.08.00 08.08.07 3

15.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-08-08 (3)

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/08/08 (x3)

17.0

POWDER COATING

POWDER COATING



M102316



(3X)

Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME: 8:15

OVEN TEMPERATURE: 320 °F

FINISH TIME: 8:45

m. L 08/08/11

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-11 (x3)

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

39952

Date: Tuesday, 29/07/2008 9:05:12 AM
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Job Number: 40772

Part Number: PB674300109

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

QC21

FINAL INSPECTION/W/O RELEASE



08/08/06
HJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08.08.26

